

Section E, Attachment 04
Solicitation No.: F5-2681-02-RFP02-1045 – CLO General Construction

SNS PIPE WELDING PROCEDURES SPECIFICATION (18350) SUMMARY

UA WPQR	WPS	BASE MATERIAL	FILLER MATERIAL	THICKNESS	COMMENTS
Carbon Steel					
22	GT11-1(PP)*	P-1 to P-1	F-6 (ER70S-2 or -3)	1/16 - 3/4	Purge optional
21,22,23	SM11-1(PP)*	P-1 to P-1	F-4 (E7015, 16, or 18)	1/16 - 3/4	No open roots
21,23	SM11-2(PP)*	P-1 to P-1	F-3 (E6010)	1/16 - 3/4	
Stainless Steel					
41,42,43	GT88-1(PP)*	P-8 to P-8	F-6 (300 Series)	0.035 - 3/4	Purge required
43	SM88-1(PP)*	P-8 to P-8	F-5 (E3XX-15 or -16)	1/16 - 3/4	
Carbon Steel to Stainless Steel					
43	GT18-2(PP)	P-1 to P-8	F-6 (ER309/309L)	1/16 - 3/4	Purge required
43	SM18-2(PP)	P-1 to P-8	F-5 (E309/309L-15 or 16)	1/16 - 3/4	

* Shared WPS

The Knight/Jacobs Joint Venture has reviewed the referenced UA WPQR above and certifies that they are applicable to, and within the allowable range of, the corresponding WSP per specification 18350.

Bruce W. Johnson
 (Original on File with the CM)
 Approved by

02/04/02

Date